

Work Order ID 160474

Friday, April 28, 2017 1:45:32 PM

160474

Page 1

Item ID: D412-702-071

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Comfort Crew Shoulder Harness

Start Date: 4/28/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 4/28/2017 Req'd Qty: 2.00

2

Customer:

Reference: RUSH

Approvals:

Process Plan:

Date: **APR 28 2017**

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN-D412-702-3

B

100

Document Control

DAS
6
9-89

0.00

APR 28 2017

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPPD412-702-071 CHG003

★**APR**

CHG001

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

DAS
6
9-89

APR 28 2017

DAS
17
89

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.06

Quality Control

②

17.04.28

⑩

DQA:

Date: 2017-05-25



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: MAY 23 2017

Work Order update only ☐

Work Order: <u>160474</u> Part No: <u>D412-702-071</u> NCR No: <u>17-6437</u>		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☒</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☒</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☒	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☒	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Date: <u>17/4/28</u>		Step #: <u>100</u>		QTY Effective: <u>(2)</u>		MRB (QSI042) Approval <u>IMP</u> <u>12</u> <u>17/4/28</u>																																																																	
Description Work Order Deviation				Disposition		Completed By <u>SMB 17/5/03</u>																																																																	
Belt made to D4305 Rev.A per customer request. Longer belt preferred by customer.				Acceptable. Belt is the functionally the same with the current revision, additional length for part comfort customer		Lead hand / Supervisor Approval Verification DAS 9 9-89 <u>17.05.02</u>																																																																	
						QC / QA Coordinator Approval DAS 9 9-89 <u>17.05.02</u>																																																																	
Root Cause <table style="width:100%;"> <tr> <td>Environment ☐</td> <td>No Re-verification ☐</td> </tr> <tr> <td>Design ☒</td> <td>Operator ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> </tr> </table>				Environment ☐	No Re-verification ☐	Design ☒	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	FAULT CATEGORY <table style="width:100%;"> <tr> <td>Pressure/Forced ☐</td> <td>Temperature/Cure ☐</td> <td>Power Loss/Surge ☐</td> <td>Positioned Wrong ☐</td> </tr> <tr> <td>Bending ☐</td> <td>Set-up ☐</td> <td>Folio/Program ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>Centre Not Concentric ☐</td> <td>BOM/Route ☐</td> <td>Grain ☐</td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Cracks ☐</td> <td>Broken/Damage/Defect ☐</td> <td>Weld ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave ☐</td> <td>Inspection Incomplete/Unqualified ☐</td> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Cuffs ☐</td> <td>Contamination ☐</td> <td>Out of Sequence ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Crushing ☐</td> <td>Countersink ☐</td> <td>Off-set ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Heat Treat ☐</td> <td>Cut Too Short ☐</td> <td>Mislabeled ☐</td> <td>Finish ☐</td> </tr> <tr> <td>Wave/Twist in Tube ☐</td> <td>Instructions Incomplete/Unclear ☐</td> <td>Fit/Function ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Marks/Chatter ☐</td> <td>Drill Holes ☐</td> <td>Misaligned/off center ☐</td> <td>Turning Sequence ☐</td> </tr> </table>				Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
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OTHER: <u>customer request</u>																																																																							

Work Order ID 160474

Friday, April 28, 2017 1:45:32 PM

160474

Page 2

Item ID: D412-702-071

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Comfort Crew Shoulder Harness

Start Date: 4/28/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 4/28/2017 Req'd Qty: 2.00

2

Customer:

Reference: RUSH

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-702-071
Location: FG029 APR 28 2017

140

QC21- Final Inspection - Work Order Release

0.00

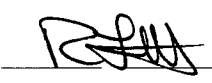
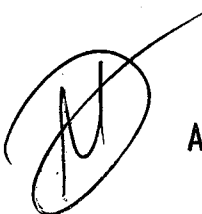
140

QC

Memo

0.20

Quality Control

 April 28/17 APR 28 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

Picklist Print

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Page 1

Work Order ID: 160474

160474

Parent Item: D412-702-071

D412-702-071

Parent Item Name: Comfort Crew Shoulder Harness

Start Date: 4/28/2017

Required Date: 4/28/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 11.03.01 new issue DD verf:EC
12.09.05 per DSI9612 DD verf:JFS

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4305-041 *D4305-041* Shoulder Harness Assembly		Manufactured	No			110	Each	2.0000	1	2	DAS 6 9-89		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST469		2							
				158522		2							
AN3-4A *AN3-4A* Bolt		Purchased	No			110	Each	81.0000	4	8	DAS 6 9-89		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST350		81							
				m136579		81							
AN4-6A *AN4-6A* BOLT		Purchased	No			110	Each	762.0000	2	4	DAS 6 9-89		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				over003		600							
				M137178		200							
				M137320		400							
				ST345		162							
				M136851		162							

APR 28 2017

APR 28 2017

APR 28 2017

DAS
27
9-89

DAS
27
9-89

DAS
27
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : ☐						
Misidentified ☐	☐	Past Due ☐							

Picklist Print

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Page 2

Work Order ID: 160474

160474

Parent Item: D412-702-071

D412-702-071

Parent Item Name: Comfort Crew Shoulder Harness

Start Date: 4/28/2017

Required Date: 4/28/2017

Start Qty: 2.00

Required Qty: 2.00

AN3-10A

Purchased

No

110

Each

228.0000

2

4

AN3-10A

Bolt

Location

Loc Qty

Loc Code

GA

60

m136787

60

ST349

168

m137321

168

MS21042L3

Purchased

No

110

Each

1,784.000

6

12

MS21042L3

Nut

Location

Loc Qty

Loc Code

FP001

91

m135945

91

GA

464

m134360

102

M136665

362

ST303

1229

m137073

11

m137166

218

m137321

1000

DAS
6
9-89

APR 28 2017

3-6
22
DAS

DAS
6
9-89

APR 28 2017

3-6
22
DAS

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date : _____		Step #: _____		QTY Effective : _____				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Description Work Order Deviation				Disposition							

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
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LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
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Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

Picklist Print

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Page 3

Work Order ID: 160474

160474

Parent Item: D412-702-071

D412-702-071

Parent Item Name: Comfort Crew Shoulder Harness

Start Date: 4/28/2017

Required Date: 4/28/2017

Start Qty: 2.00

Required Qty: 2.00

MS21042L4

Purchased

No

110

Each

2,018.000

2

4

MS21042L 4

Nut

Location

Loc Qty

Loc Code

FP001

10

m133363

10

GA

148

m135058

148

OVER007

1588

m137321

1588

ST303

272

m136986

3

m137166

269

NAS1149D0332J

Purchased

No

110

Each

789.0000

10

20

NAS1149D0332.J

Washer

Location

Loc Qty

Loc Code

FP

260

m136015

8

m137075

252

FP001

23

m137075

23

GA

138

m136643

138

ST264

368

m136015

0

m136643

368

DAS

6

9-89 APR 28 2017

DAS

27

9-89

DAS

6

9-89

APR 28 2017

DAS

27

9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

Friday, April 28, 2017 1:45:31 PM

Page 4

Work Order ID: 160474

Parent Item: D412-702-071

Parent Item Name: Comfort Crew Shoulder Harness

160474

D412-702-071

Start Date: 4/28/2017

Required Date: 4/28/2017

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0363J

Purchased

No

110

Each

901.0000

6

12

NAS1149D0363.I

Washer

9-89 **APR 28 2017** 9-89

Location

Loc Qty

Loc Code

GA

42

m134055

42

ST263

859

m137061

100

m137164

759

NAS1149D0432J

Purchased

No

110

Each

271.0000

4

8

NAS1149D0432.I

WASHER

9-89 **APR 28 2017** 9-89

Location

Loc Qty

Loc Code

GA

24

m131026

24

ST264

247

m134676

247

NAS1149D0463J

Purchased

No

110

Each

2,861.000

4

8

NAS1149D0463.I

Washer

9-89 **APR 28 2017** 9-89

Location

Loc Qty

Loc Code

GA

48

M135056

48

ST260a

2000

M137381

2000

ST263

813

M136983

213

M137166

600

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval																																																																
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OTHER : ☐																																																																							

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-702-071	-2.6 lb	± 22.0 in	± 57.2 in lb	47.0 in	-122.2 in lb
<i>Pilot/Co-pilot Shoulder Harness Kit</i>	-1.2 kg	± 0.56 m	± 0.67 m kg	1.19 m	-1.43 m kg
D412-702-073	-2.6 lb	± 22.0 in	± 57.2 in lb	47.0 in	-122.2 in lb
<i>Pilot/Co-pilot Shoulder Harness Kit</i>	-1.2 kg	± 0.56 m	± 0.67 m kg	1.19 m	-1.43 m kg
D412-702-075	-2.6 lb	± 22.0 in	± 57.2 in lb	47.0 in	-122.2 in lb
<i>Pilot/Co-pilot Shoulder Harness Kit</i>	-1.2 kg	± 0.56 m	± 0.67 m kg	1.19 m	-1.43 m kg

5.0 PARTS LISTS

QTY -071	QTY -073	QTY -075	Part Number	Description
X			D412-702-071	Dart Pilot/Co-Pilot Shoulder Harness Kit
	X		D412-702-073	Dart Pilot/Co-Pilot Shoulder Harness Kit
		X	D412-702-075	Dart Pilot/Co-Pilot Shoulder Harness Kit
1			D4305-041	SHOULDER HARNESS
	1		D4305-043	SHOULDER HARNESS
		1	D4305-045	SHOULDER HARNESS
4	4	4	AN3-4A	BOLT
2	2	2	AN4-6A	BOLT
2	2	2	AN3-10A	BOLT
6	6	6	MS21042L3	NUT
2	2	2	MS21042L4	NUT
10	10	10	NAS1149D0332J	WASHER
6	6	6	NAS1149D0363J	WASHER
4	4	4	NAS1149D0432J	WASHER
4	4	4	NAS1149D0463J	WASHER

PD
17-04-29

Work Order ID 160474

160474

Page 1

Friday, April 28, 2017 1:45:32 PM

Item ID: D412-702-071

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Comfort Crew Shoulder Harness

Start Date: 4/28/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 4/28/2017 Req'd Qty: 2.00

2

Customer:

Reference: RUSH

Run Start *NR1*

Approvals:

Process Plan:

Date: APR 28 2017

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D412-702-3	B								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPPD412-702-071								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.06							
Quality Control									

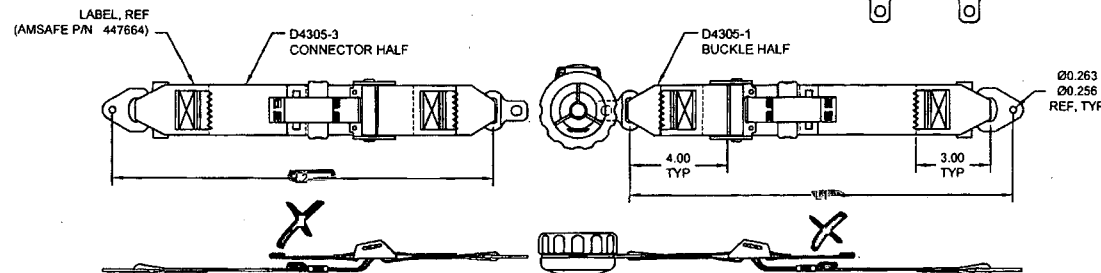
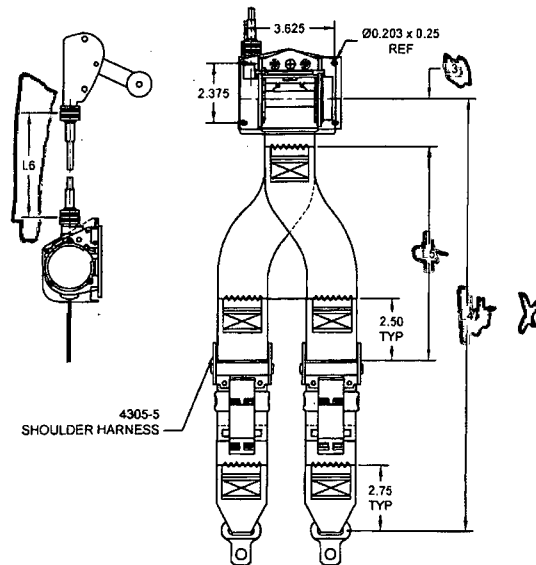
APR 28 2017
DAS
21
9-89

CHG003
CHG001

CB (2) 17-04-28

SPECIFICATION CONTROL DRAWING

DART P/N	VENDOR P/N	DESCRIPTION	VENDOR	L1	L2	L3	L4	L5	L6
D4305-1	4181-201	BUCKLE HALF	AMSAFE	24.00					
D4305-3	4181-203	CONNECTOR HALF	AMSAFE		24.00				
D4305-5	4181-207	SHOULDER HARNESS	AMSAFE			40.00	65.00	18.00	30.00



NOTES:

- 1) PURCHASE: AMSAFE INC. P/N 4181-2-151-2396
4 POINT SHOULDER HARNESS WITH BUCKLE ASSEMBLY.
MEETS REQUIREMENTS OF TSO-C114
CHROME HARDWARE PLATING AND BLACK WEBBING
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: LABEL TO CONTAIN THE FOLLOWING AT MINIMUM:
PART No. 4181-2-151-2396
CUST P/N: D4305-041
RATED: 3000 LBS DATE OF MFG
CONFORMS TO TSO-C114
- 7) WEIGHT: 3.36 lbs

D4305-041 SHOULDER HARNESS

REV.	DESCRIPTION	RF	DATE
A	NEW ISSUE	RF	10.11.26
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. A DSC-D4305 SHEET 1 OF 1 TITLE SCALE SHOULDER HARNESS NTS	
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF	DATE 10.11.26 COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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